

Work Order ID 162735

Monday, June 12, 2017 10:05:58 AM

Ship July 7
162735

Page 1

Item ID: D350-766-015

Revision ID:

Item Name: Interior Trim - Canopy Post

Start Date: 6/13/2017 Start Qty: 2.00

Required Date: 6/21/2017 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUN 12 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-766

C

JUL 11 2017**DAS**
6
9-89

100

Document Control

DOCUMENT CONTROL

0.00

100

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-766-015 CHG001

3 **DAS**
27
9-89**JUL 20 2017**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3 **JUL 20 2017****DAS**
6
9-89**DAS**
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

3 **DAS**
27
9-89**JUL 20 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 162735

Monday, June 12, 2017 10:05:58 AM

162735

Page 2

Item ID: D350-766-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Interior Trim - Canopy Post

Start Date: 6/13/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/21/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-766-015
Location : FG117

3

DAS
27
9-89

JUL 20 2017

1X
2X sold

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

DAS
21
9-89

JUL 20 2017

Quality Control

JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								

Picklist Print

Page 1

Monday, June 12, 2017 10:06:02 AM

Work Order ID: 162735

162735

Parent Item: D350-766-015

D350-766-015

Parent Item Name: Interior Trim - Canopy Post

Start Date: 6/13/2017

Required Date: 6/21/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3946-1 *D3946-1* Panel, Center Post (Sub-Comp D350-766-015)		Manufactured	No			110	Each	0.0000	1 **	23 162767	6 9-89	JUL 20 2017	DAS 28 9-89
D3947-1 *D3947-1* Panel, Upper Left Post (Sub-Comp D350-766-015)		Manufactured	No			110	Each	0.0000	1 **	23 162770	6 9-89	JUL 20 2017	DAS 28 9-89
D3947-2 *D3947-2* Panel, Upper Right Post (Sub-Component D350-766-015)		Manufactured	No			110	Each	0.0000	1 **	23 162769	6 9-89	JUL 20 2017	DAS 28 9-89
D3947-3 *D3947-3* Panel, Lower Left Post (Sub-Comp D350-766-015)		Manufactured	No			110	Each	0.0000	1 **	23 162770	6 9-89	JUL 20 2017	DAS 28 9-89
D3947-4 *D3947-4* Panel, Lower RH Post (Sub-Component D350-766-015)		Manufactured	No			110	Each	0.0000	1 **	23 162771	6 9-89	JUL 20 2017	DAS 28 9-89

DAS
27
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : _____									

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg
D350-766-015 Interior Trim Kit (Canopy Post Trim Kit)	5.2 lb 2.4 kg	0 in 0 m	0 in-lb 0 m-kg	42 in 1.07 m	218 in-lb 2.6 m-kg
D350-766-021 Interior Protector Kit (Aft Baggage Protector Kit)	14.3 lb 6.5 kg	2.77 in 0.07 m	39.6 in-kg 0.46 m-kg	168 in 4.27 m	2402 in-lb 27.8 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -021	Part Number	Description
X				D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X			D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
		X		D350-766-015	INTERIOR TRIM KIT (CANOPY POST TRIM KIT)
			X	D350-766-021	INTERIOR PROTECTOR KIT (AFT BAGGAGE PROTECTOR KIT)
1				D3655-1	PANEL
1				D3655-3	PANEL
	1			D3656-1	PANEL
	1			D3656-3	PANEL
			1	D3889-041	PANEL, FLOOR
			1	D3890-041	PANEL, WALL
			1	D3891-041	PANEL, FWD LH
			1	D3891-042	PANEL, FWD RH
			1	D3944-1	PLACARD
			4	D3945-041	BRACKET
		1		D3946-1	PANEL, CENTER POST
		1		D3947-1	PANEL, UPPER LH POST
		1		D3947-2	PANEL, UPPER RH POST
		1		D3947-3	PANEL, LOWER LH POST
		1		D3947-4	PANEL, LOWER RH POST
			3	D3948-041	PLATE, ANCHOR
			4	D3948-043	PLATE, ANCHOR
			14	AN525-10R7	SCREW
			4	AN525-10R9	SCREW
2				AN526-1032R12	SCREW
2				AN526-1032R20	SCREW
	15			AN526-1032R9	SCREW
			8	CCR264SS3-2	RIVET
	30			CCR264SS3-3	RIVET
8				CCR274SS3-4	RIVET
			8	CR3213-4-02	RIVET (OR M7885/2-4-02)
			12	CR3523-4-02	RIVET (OR M7885/4-4-02)
			16	CR3523-4-03	RIVET (OR M7885/4-4-03)
4	15		4	MS21059L3	NUTPLATE (OR MS21059-3)

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Revision: C

Date: 09.06.08



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH08-5

Issue No.: 1

Approval Date: April 03, 2008

Issue Date: April 03, 2008

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

EUROCOPTER AS 350 B, AS 350 B1, AS 350 B2, AS 350 B3,
AS 350 BA, AS 350 D, AS 350 D1, AS 355 E, AS 355 F, AS
355 F1, AS 355 F2, AS 355 N, AS 355 NP

Canadian Type Certificate or Equivalent:

AS 350 Series H-83
AS 355 Series H-87

Description of Type Design Change:

Thermoformed D350-766 Interior Trim Kits

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of Interior Trim Kits to be in accordance with DART Aerospace Ltd. Installation Instructions IIN-D350-766, Rev A dated March 3, 2008 or later Transport Canada approved revision.

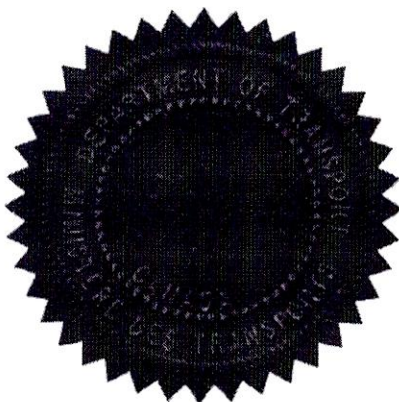
Manufacture of Interior Trim Kits to be in accordance with DART Aerospace Ltd. Master Document List MDL-D350-766, Rev A dated March 3, 2008 or later Transport Canada approved revision.

Instructions for Continued Airworthiness contained in DART Aerospace LTD. Document ICA-D350-766, Rev 0 dated March 3, 2008 or later Transport Canada accepted revision, are required with this installation.

Basis of Certification is CFR 14, Part 27 amendment 27-40 for affected areas except FAR 27.561 which is at amendment 27-0.

— End —

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.



Greg Oucharek
For Minister of Transport

Canada